

Work Order ID 65642

Thursday, January 20, 2011 3:06:05 PM



Page 1

ASAP

Item ID: D3137-3

Revision ID:

Item Name: Guide

Start Date: 1/21/2011 Start Qty: 10.00

Required Date: 1/24/2011 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Run Start



Stop

Approvals: Process Plan: mf Date: 11-01-20 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3137 | Rev F |

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blanks. Blank size: 1.250" x .750" x .950" long

0.00

0.00

ul 11. 1. 24

30

✓

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per Folio FA242 & Dwg D3137□2-Deburr

0.00

0.00

ul 11. 1. 24

30

✓

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

ul 11. 1. 24

30

✓

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 65642

Thursday, January 20, 2011 3:06:05 PM

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Item ID: D3137-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Guide

Start Date: 1/21/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 1/24/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

J.F.S. 11/01/24

30

Quality Control

140

Identify as per dwg & Stock Location 235B

0.00



Packaging

Memo

0.00

11/1/24 SP (302)

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

CK 11/01/24
ME

Quality Control

11-01-24

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, January 20, 2011 3:06:02 PM

Page 1

Work Order ID: 65642

Parent Item: D3137-3

Parent Item Name: Guide




Start Date: 1/21/2011

Required Date: 1/24/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 02.05.29 New Issue NG
IPP Rev:B 08-05-23 revE as per dwg DD verified by:EC
IPP Rev c 08.07.03 ECN1207 EC verified by DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MDELRLNB0.75X1.250  | | Purchased | No | | | 100 | f | 22.7524 | 0.0791 | 0.832632 | | 11.1.24 | |
| Delrin Bar | | | | | | | | | | | | | |

Location

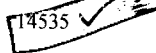
Loc Qty

Loc Code

MAT050

22.7524

22.7524



2.5+

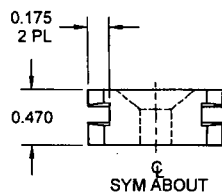
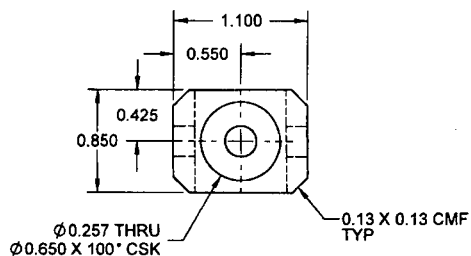
| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

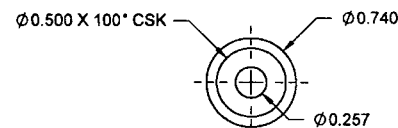
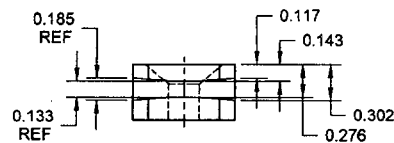
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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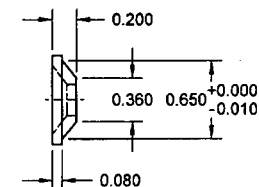
NOTE: Date & initial all entries



D3137-3 GUIDE



D3137-5 WASHER



NOTES:

- 1) MATERIAL: -3
DELFIN II 150E OR ACETRON GP ACETAL, BAR
(REF DART SPEC M-DELFIN-B)
-5
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)
OR PER-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207
-5 REPLACES PREMIER P/N B30-2300-209

#65642

RELEASED
180707-14

| | | | |
|------------|----------|--|--------------|
| DESIGN | DS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | LAJS | | |
| CHECKED | LAJS | DRAWING NO. | REV. F |
| MFG. APPR. | LAJS | D3137 | SHEET 5 OF 5 |
| APPROVED | LAJS | TITLE | SCALE |
| DE APPR. | LAJS | BRACKET ASSEMBLY | NTS |
| DATE | 08.05.30 | <small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

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| DART AEROSPACE LTD | | Work Order: 65642 |
| Description: Guide | | Part Number: D3137-3 |
| Inspection Dwg: D3137 | Rev: F | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 0.175 | +/-0.010 | .177 | / | | ml-02 | |
| Ø0.257 | +0.005/-0.000 | .260 | / | | | |
| Ø0.65 x 100° | +/-0.030 | .660 | / | | | |
| 0.425 | +/-0.010 | .425 | / | | | |
| 0.550 | +/-0.010 | .550 | / | | | |
| 1.100 | +/-0.010 | 1.100 | / | | | |
| 0.470 | +/-0.010 | .470 | / | | | |
| 0.850 | +/-0.010 | .853 | / | | | |
| 0.143 | +/-0.010 | .139 | / | | | |
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| Measured by: ml |
| Date: 11.1.24 |

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|---------------------------|
| Audited by: J.F.S. |
| Date: 11/01/24 |

| | |
|----------------------------|-----|
| Prototype Approval: | N/A |
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | 03.11.27 | New Issue | KJ/RF | |
| B | 04.11.12 | 0.175 was 0.145 & Ø0.65 x 100° was Ø0.75 x 100° | KJ/JLM | |
| C | 06.03.15 | Dwg Rev updated | KJ/JLM | |
| D | 08.12.02 | Dwg Rev updated | KJ/DD | |

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